

Date: Thursday, 3/8/2007 1:11:59 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 31113	
Estimate Number : 10613	
P.O. Number : NIA	Part Number : D265615
This Issue : 3/8/2007 S.O. No. : NIA	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 3/8/2007 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 29335	Material : NIA
Written By : _____	Due Date : 3/30/2007 Qty: 20 Um: Each
Checked & Approved By : <u>02.03.08</u>	
Comment : Est: D 02.10.25 Re-format KJ	
Est Rev:E Now on Waterjet 06-09-25 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S20GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.6431 sf(s)/Unit Total : 12.8625 sf(s)
 1010/1025/A21/6aA SHEET (.040")
 (M1010S20GA)
 Batch: **M104453**

SAD 07/05/27 (20)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D2656
 Dwg Rev: **D**
 Prog Rev: **D**

SAD 07/05/27 20
20

2-Deburr if necessary

0.07 07.06.16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/27 20

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07.05.27 20

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261and DT8326
 2-Form joggle as per Dwg D2656 using Jig DT8158
 3-Identify as D2656-15

SAD 07/06/21 (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 27/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/8/2007 1:12:00 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 31113

Part Number: D265615

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Canto
Fin 07/06/22 (170)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BR/M 07-08-21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F2 *07/06/22 (20)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *F-P-14*

m.d 07/06/22

(20X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/22

Job Completion



u 07-06-22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

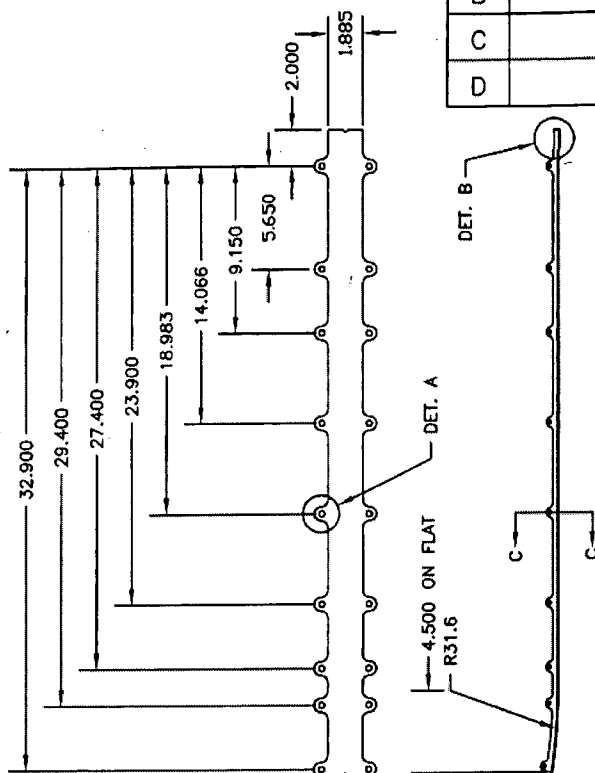
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

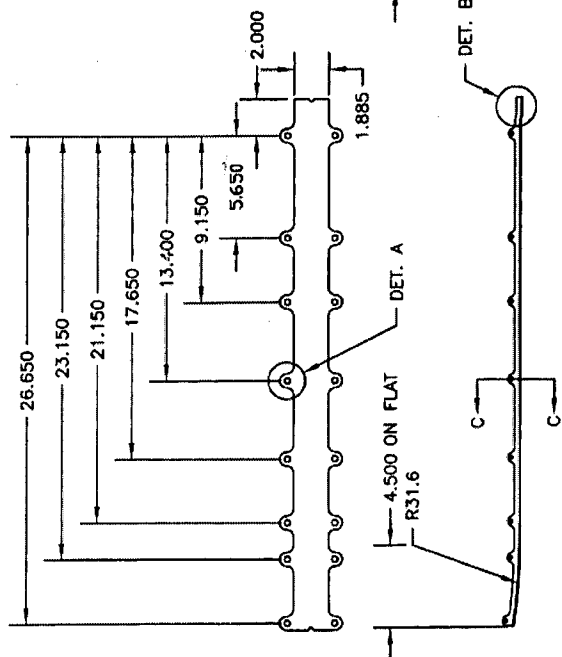


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DS		CP		PORT HADLOCK, WA	
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				D2656	SHEET 1 OF 4
DATE				TITLE	SCALE
05.08.17				WEARSHOE	1:10
A	97:03:25			NEW ISSUE	
B	97:06:02			CHANGED TABS	
C	97:06:26			R31.6 WAS R19.5	
D	05.08.17			ENLARGE ALL HOLES TO IMPROVE FIT	

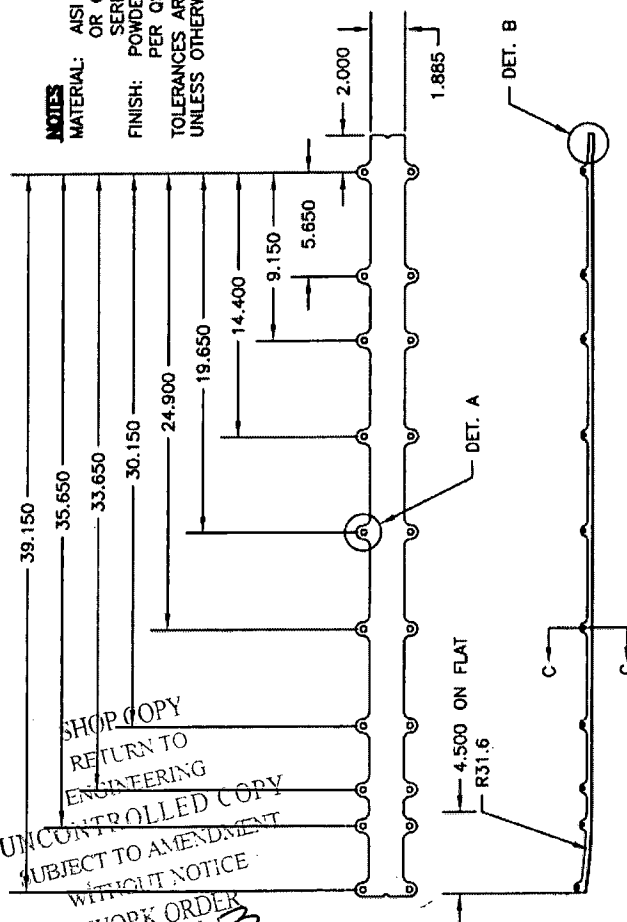
D2656-13



D2656-11



D2656-15



NOTES
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
05.09.08

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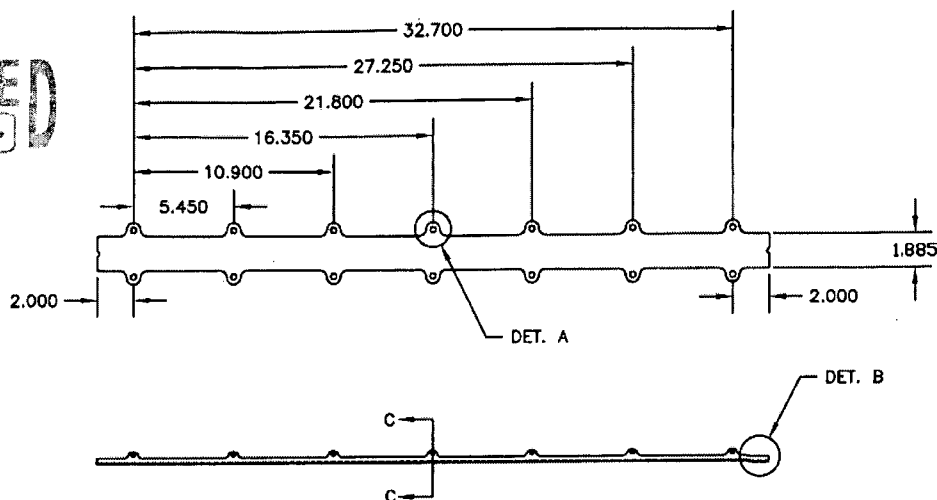
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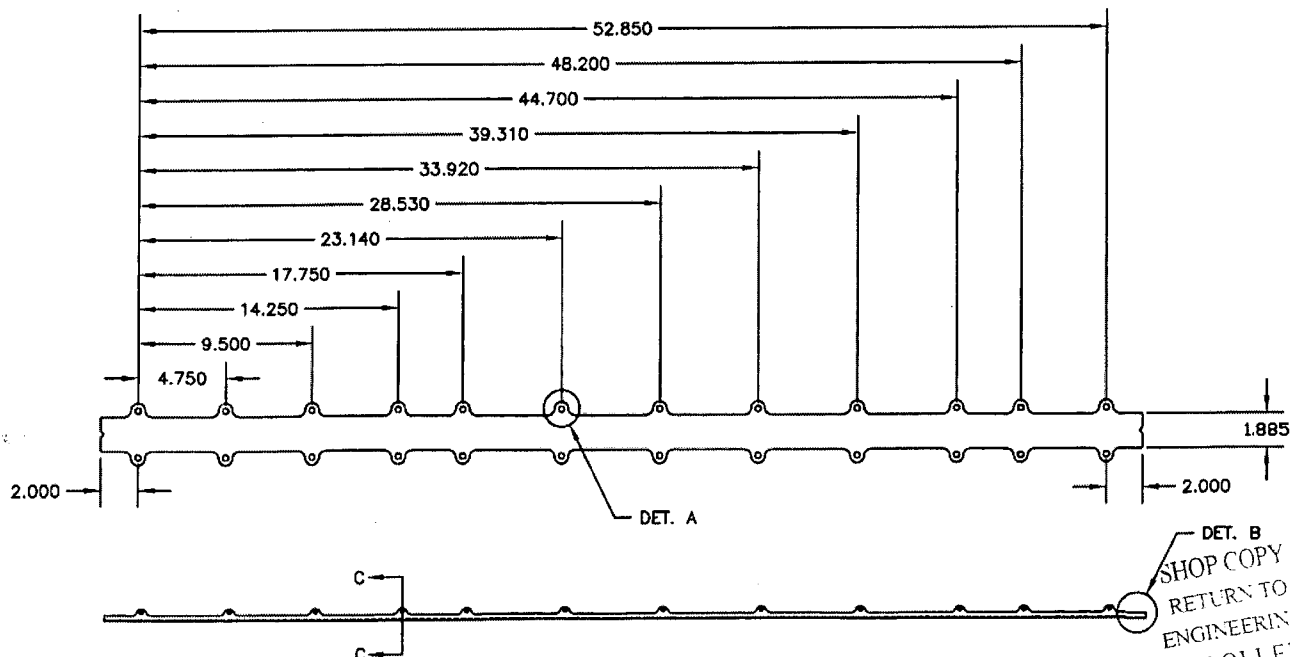
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				REV. D
DATE	05.08.17	TITLE	WEARSHOE	SHEET 2 OF 4
				SCALE 1:10

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05.07.06 *[Signature]*

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
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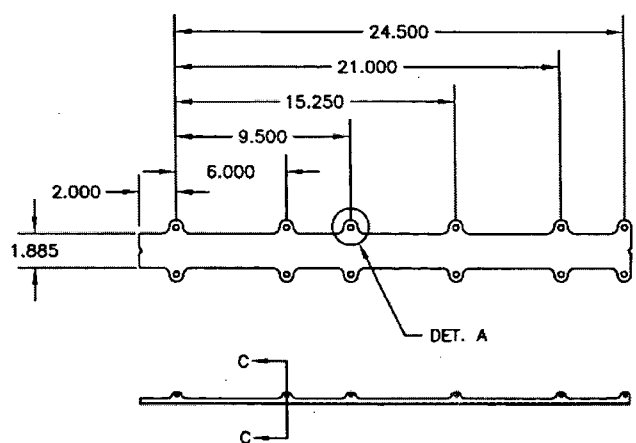
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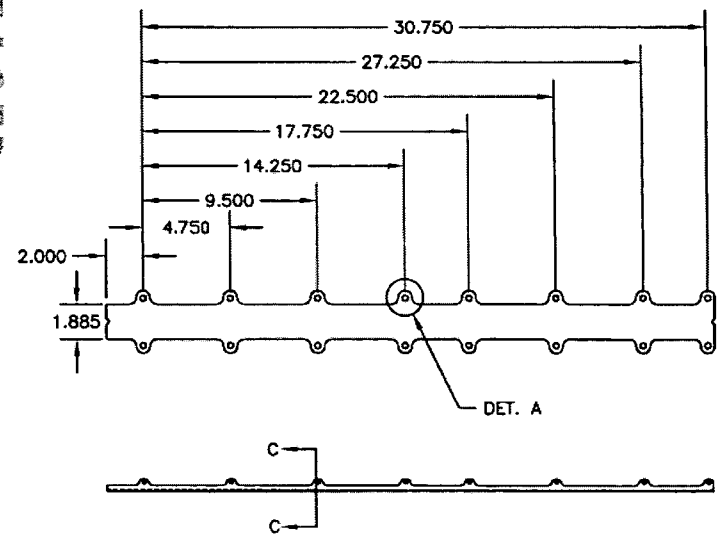
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DATE	05.08.17	DRAWING NO.	D2656	REV. D
		TITLE	WEARSHOE	SHEET 3 OF 4
		SCALE	1:10	

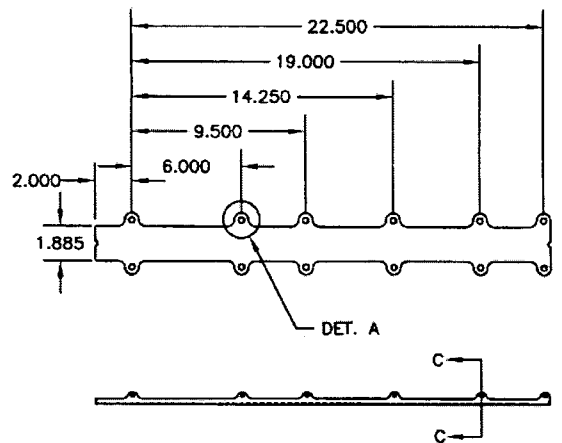
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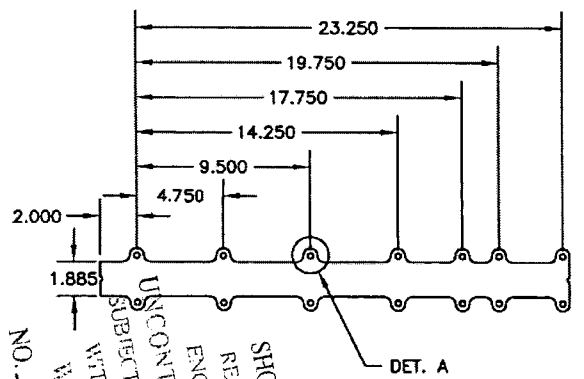
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D2656-31



D2656-35



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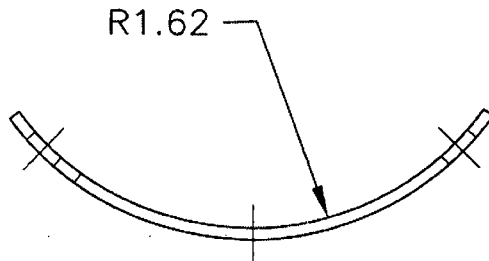
NOTES
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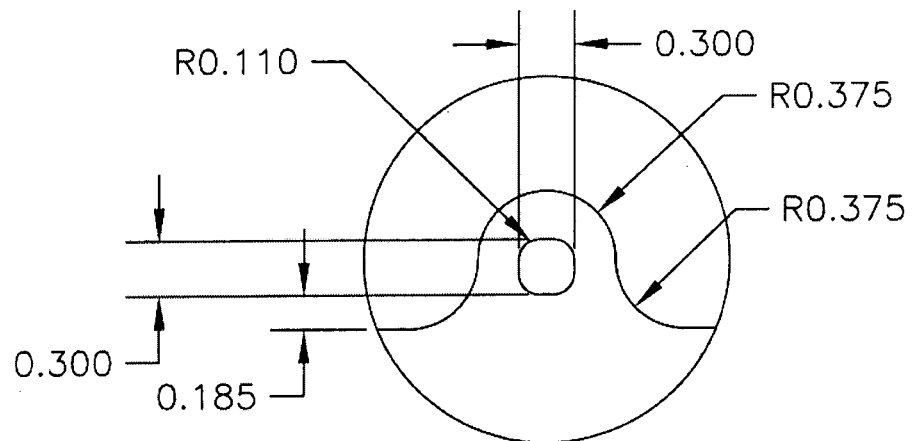
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

SECTION C-C

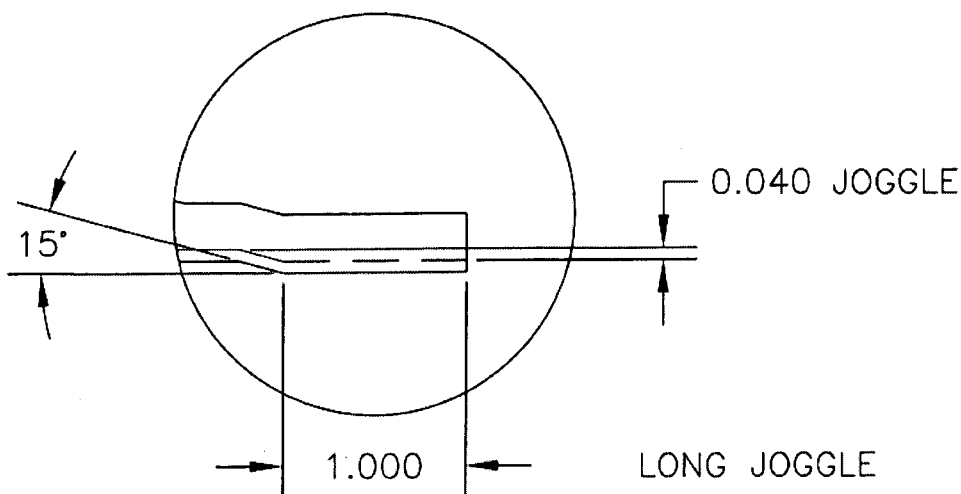


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DETAIL A



DETAIL B



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DART AEROSPACE LTD		Work Order: 31113
Description: WEARSHOE		Part Number: 0265615
Inspection Dwg: 02656 Rev: 0		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 39.150	+/- 0.010	39.150	✓		M-T	
B 35.650	+/- 0.010	35.650	✓		M-T	
C 33.650	+/- 0.010	33.650	✓		M-T	
D 30.150	+/- 0.010	30.150	✓		M-T	
E 24.900	+/- 0.010	24.900	✓		M-T	
F 19.650	+/- 0.010	19.650	✓		M-T	
G 14.400	+/- 0.010	14.400	✓		M-T	
H 9.150	+/- 0.010	9.155	✓		Vern	
I 5.650	+/- 0.010	5.652	✓		Vern	
J 2.000	+/- 0.010	2.005	✓		height gage	
K 1.885	+/- 0.010	1.891	✓		Vern	
L 0.300	+/- 0.010	0.301	✓		Vern	
M 0.300	+/- 0.010	0.292	✓		Vern	
N 0.040	+/- 0.010	0.036	✓		Vern	
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: JAD	Audited by: SG	Prototype Approval:	N/A
Date: 07/05/26	Date: 07.05.27	Date:	N/A
Rev	Date	Change	Revised by
		New Issue	KJ/RF
			Approved

